

Date: Thursday, 18/12/2008 12:51:40 PM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TAIL LIGHT FAIRING
Job Number : 44170	
Estimate Number : 12359	
P.O. Number :	Part Number : D34841
This Issue : 18/12/2008 S.O. No. :	Drawing Number : D3484 UNDER REVIEW <i>JE 08.12.19</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : 18/12/2008 Type : SMALL /MED FAB	Drawing Revision : <i>DE</i>
Previous Run : 34456	Material :
Written By :	Due Date : 23/12/2008 Qty: 4 Um: Each
Checked & Approved By : <i>JLD 08.12.19</i>	
Comment : Est Rev:A New Issue 06-04-11 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S050	6061-T6 .050 Sheet
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Comment: Qty.: 0.3505 sf(s)/Unit Total : 1.4020 sf(s)

6061-T6 .050 Sheet

(M6061T6S050)

Batch: *104186* *IB 9-1-5*



2.0	WATER JET <i>104186</i>	FLOW WATER JET
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Comment: FLOW WATER JET

Cut as per Dwg D3484

*FF*  
*IB 9-1-5*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*IB 9-1-5*

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

*S 09/01/05 (46)*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

*1-Debur n/a*

2-Roll as per Dwg D3484

*FF 09/01/28*

*(6)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 18/12/2008 12:51:40 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 44170

Part Number: D34841

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

80101/28 (64H)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: MISC

09-01-28 80 09-01-28

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/29

Job Completion



MF 09-01-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



8

7

6

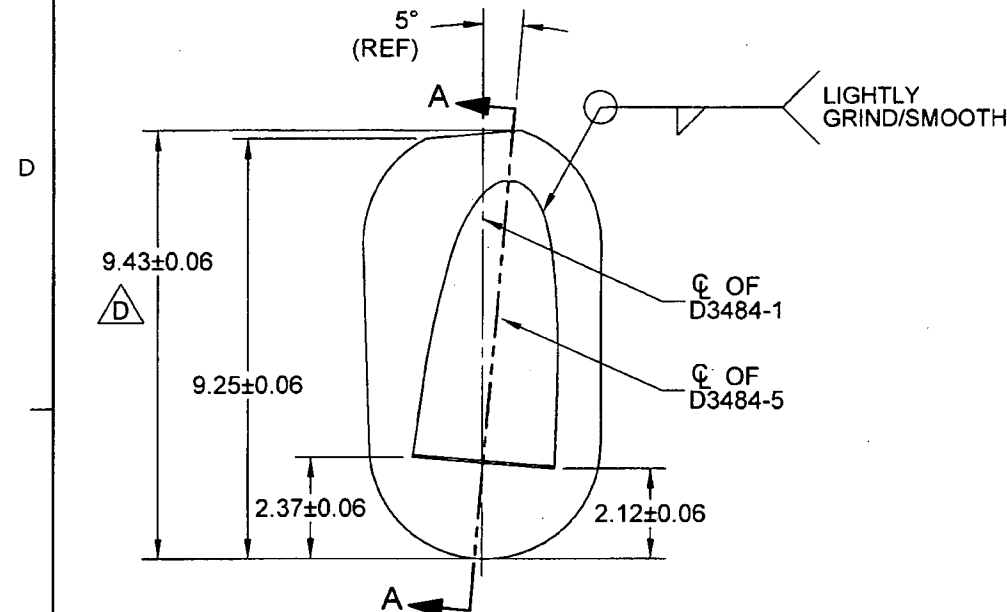
5

4

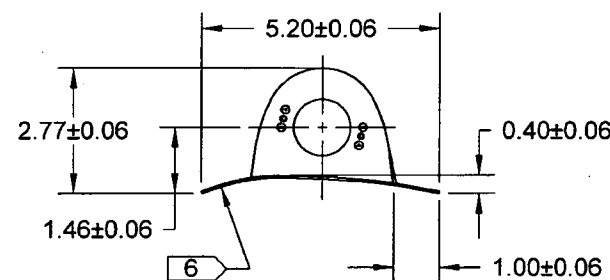
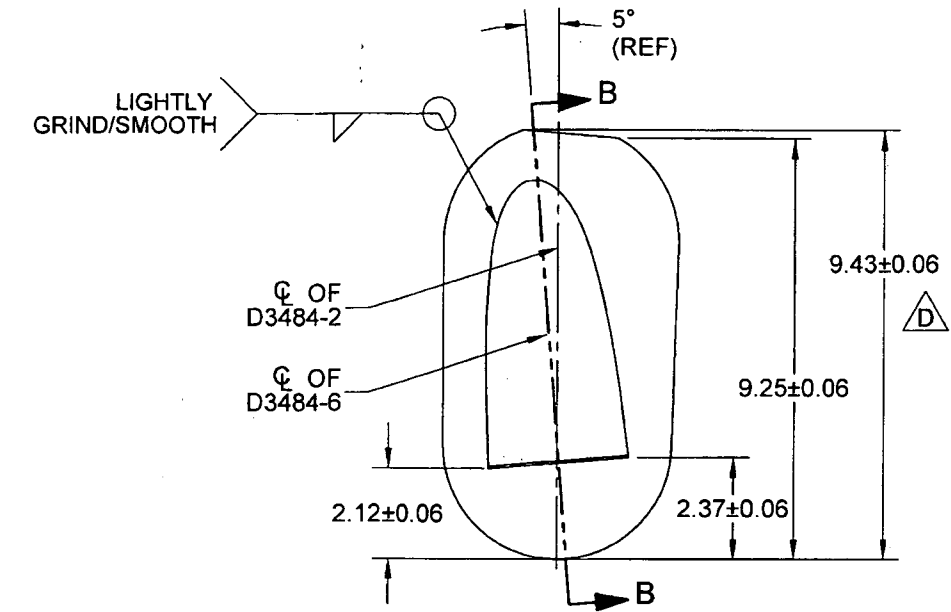
3

2

1



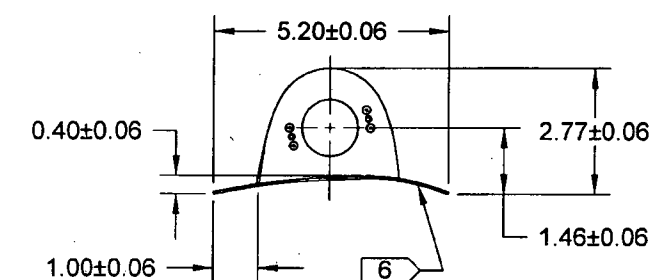
QTY -041	QTY -042	P/N	DESCRIPTION
X		D3484-041	TAIL LIGHT FAIRING ASSEMBLY (LH)
	X	D3484-042	TAIL LIGHT FAIRING ASSEMBLY (RH)
1		D3484-1	BASE (LH)
	1	D3484-2	BASE (RH)
1		D3484-3	FACE (LH)
	1	D3484-4	FACE (RH)
1		D3484-5	CONE (LH)
	1	D3484-6	CONE (RH)
4	4	CR1122-3-02.5	RIVET
2	2	MS21069-04	ANCHOR NUT



SECTION A-A

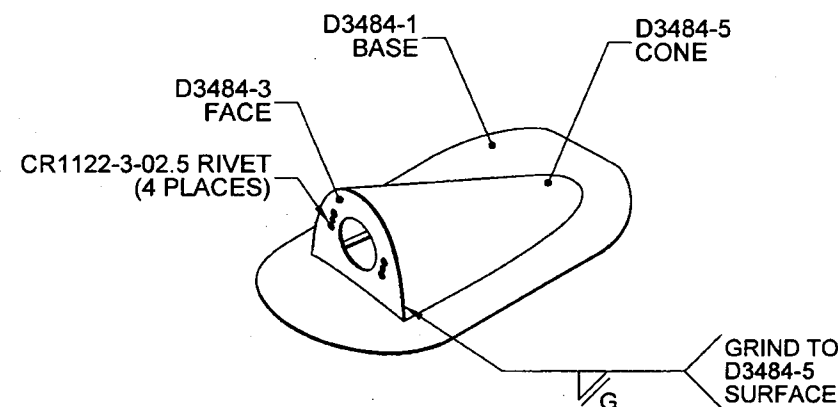
INSTALL MS21069-04  
ANCHOR NUT  
(2 PLACES)

SECTION B-B

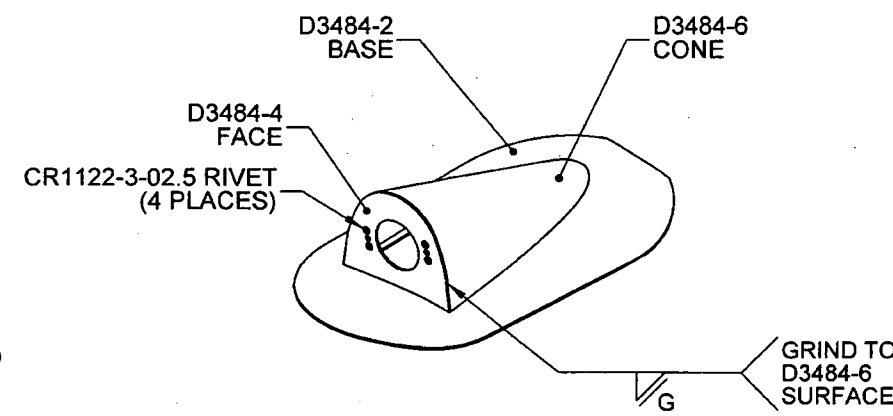


D3484-041 TAIL LIGHT FAIRING

D3484-042 TAIL LIGHT FAIRING



D3484-041 ISOMETRIC VIEW



D3484-042 ISOMETRIC VIEW

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) WELDING: PER DART QSI 004
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D412-750-141/-142 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA06-13"
- 7) WEIGHT: 0.30 lbs

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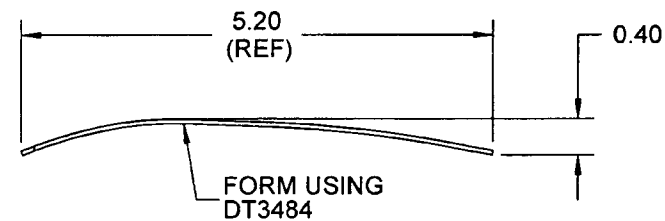
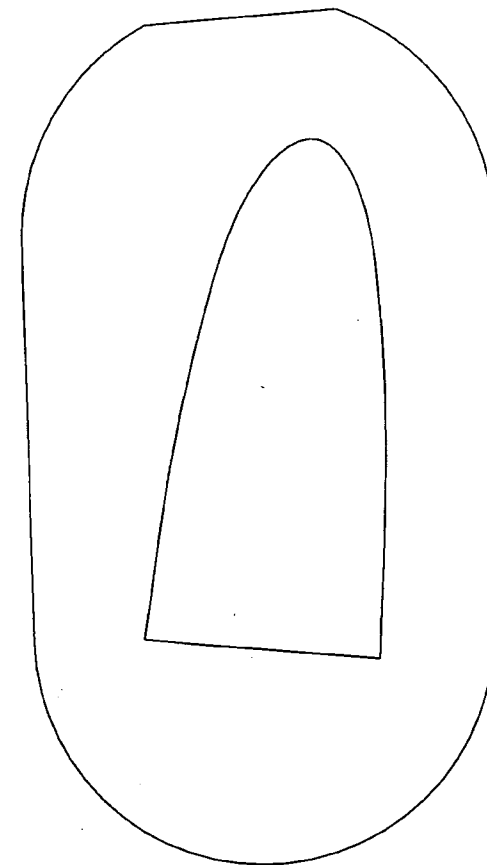
E	REDRAWN/REFORMAT TO SHOW LH AND RH CONFIGURATIONS FOR CLARITY; CORRECT VIEWS ON SHEET 3 & 4 (WAS SHOWING MIRROR IMAGE OF PARTS); DIM 1.560 WAS 1.563 (SHEET 3, ZONE B4); CR1122-3-02.5 RIVET WAS MS20426AD3-3 RIVET	MB	08.01.03
D	CORRECT D3484-1F	MB	06.06.22
C	RE-DESIGN D3484-3F/-5F	MB	06.04.20
B	RE-DESIGN	MB	06.02.21
A	NEW ISSUE	MB	05.11.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.01.03		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

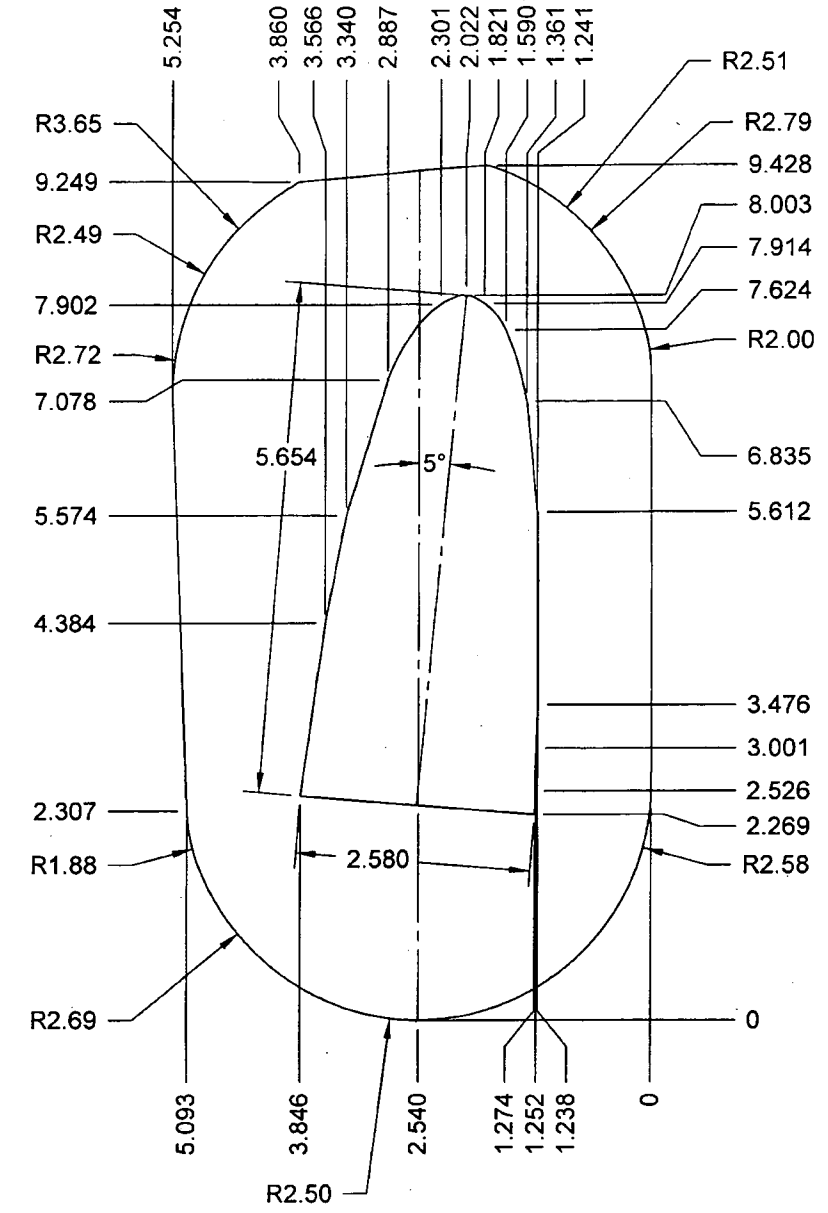
DRAWING NO. **D3484** REV. E  
SHEET 1 OF 4

TITLE **TAIL LIGHT FAIRING** SCALE 1:4

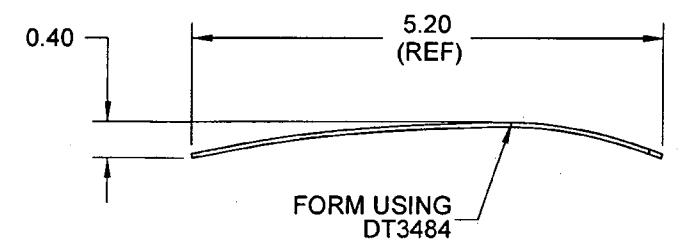
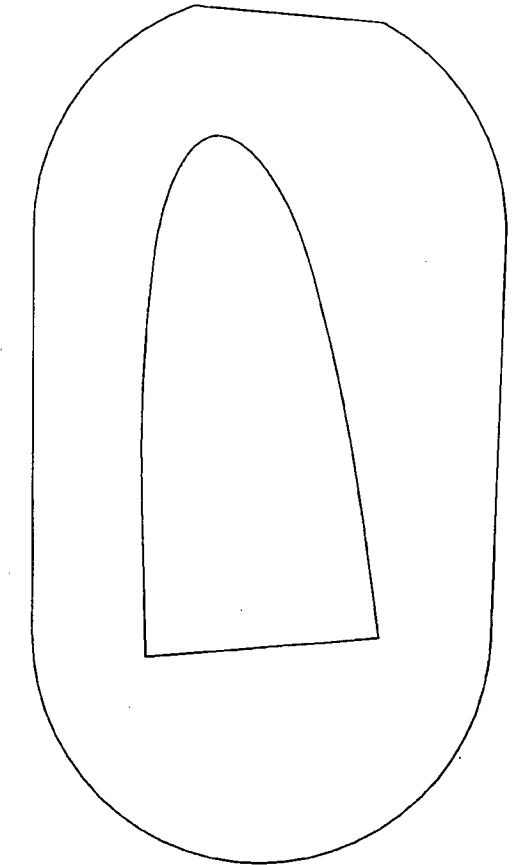
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**D3484-1 BASE**  
(MAKE FROM D3484-1F)



**D3484-1F BASE FLAT PATTERN**



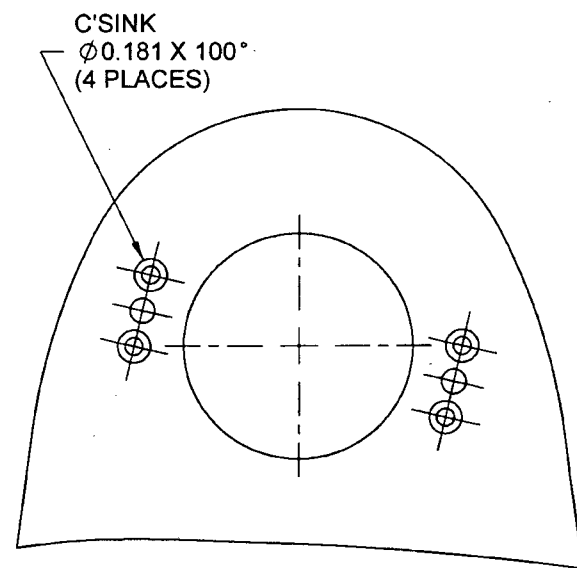
**D3484-2 BASE**  
(MAKE FROM D3484-1F)

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.050)
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.16 lbs

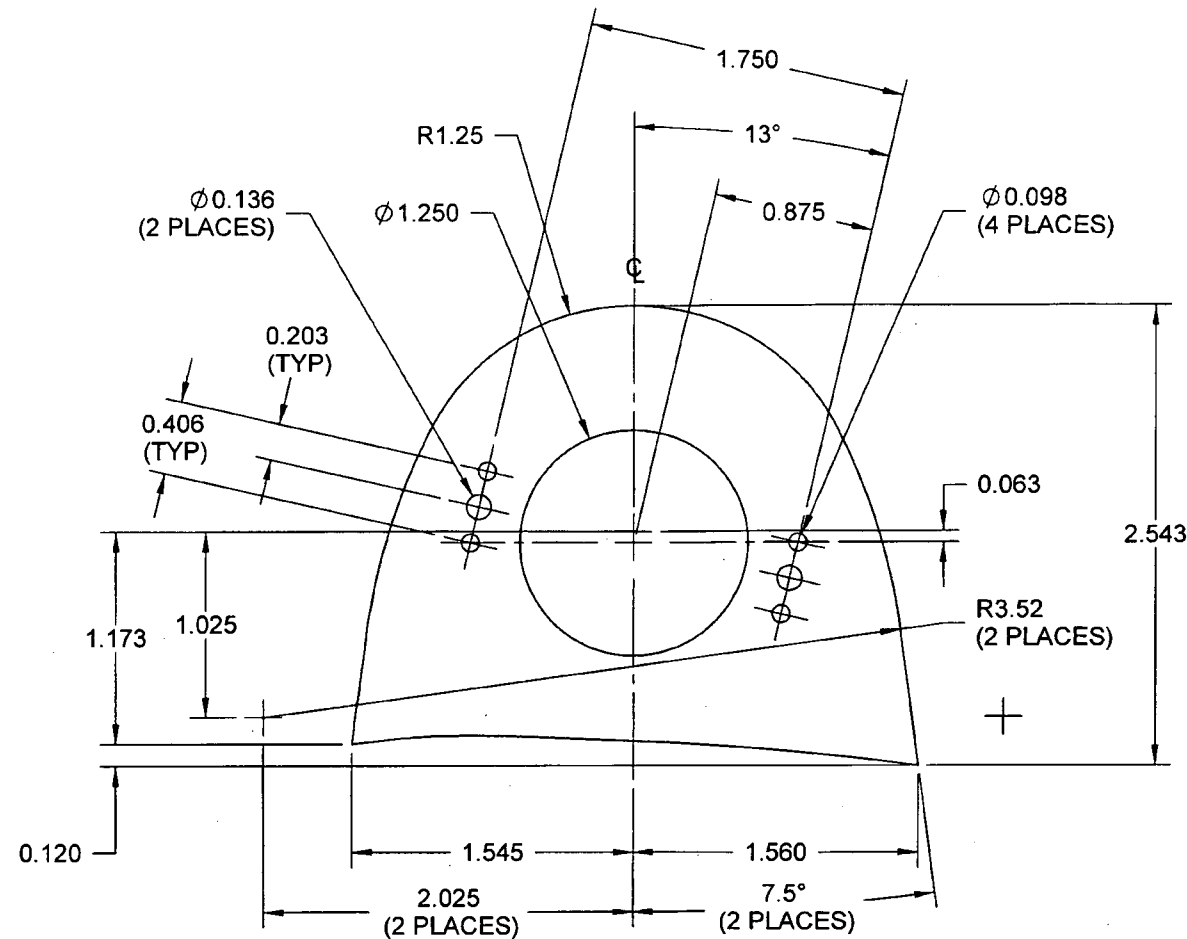
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08-01-17

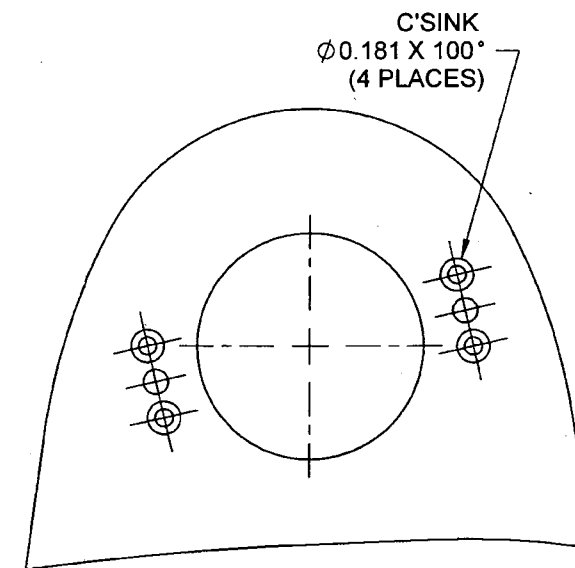
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3484	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TAIL LIGHT FAIRING	1:2
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**D3484-3 FACE**  
(MAKE FROM D3484-3F)



**D3484-3F FLAT PATTERN TAIL LIGHT FAIRING**



**D3484-4 FACE**  
(MAKE FROM D3484-3F)

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

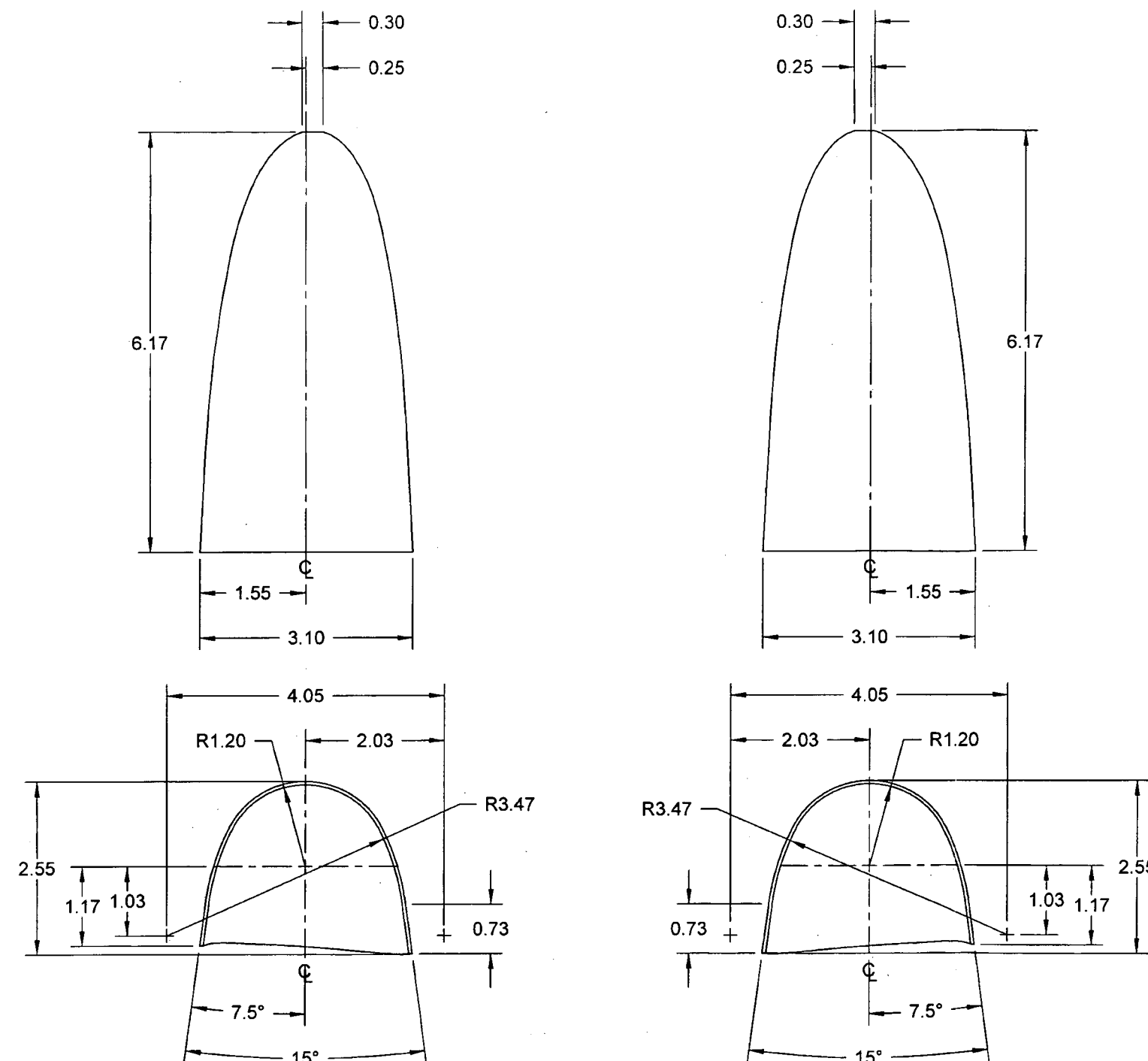
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MFG. APPR.			SHEET 3 OF 4
APPROVED		TITLE <b>TAIL LIGHT FAIRING</b>	SCALE 1:1
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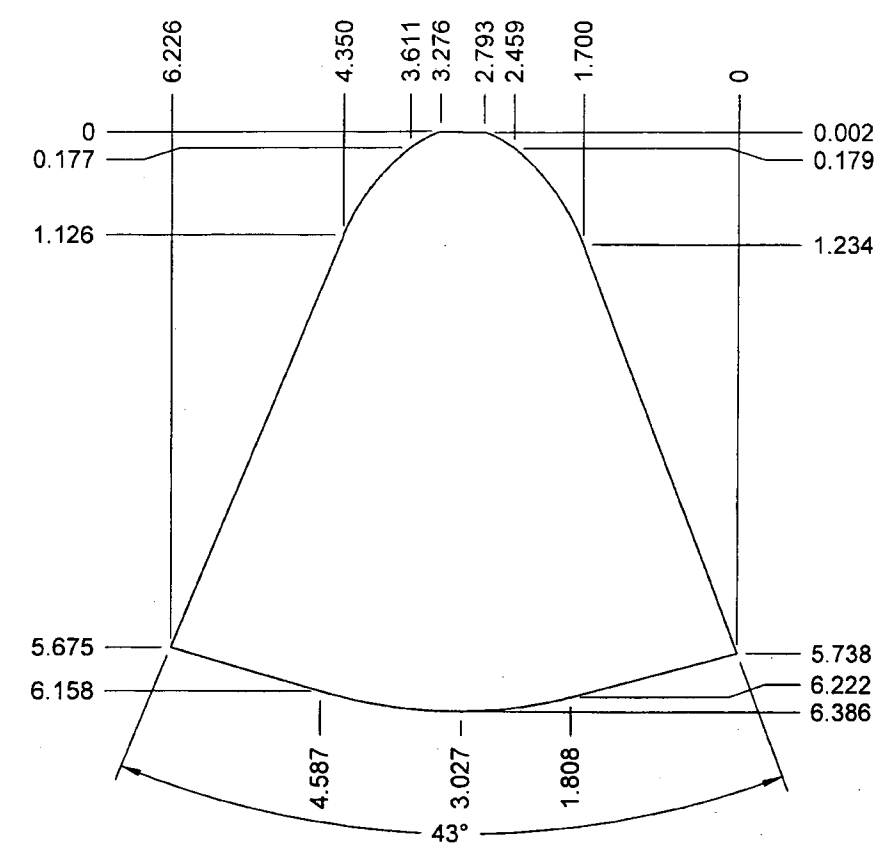


8 7 6 5 4 3 2 1



**D3484-5 CONE**  
(MAKE FROM D3484-5F)

**D3484-6 CONE**  
(MAKE FROM D3484-5F)



**D3484-5F CONE FLAT PATTERN**

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.050)
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.11 lbs

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APPROVED		TITLE	SCALE
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